

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 144909

April 27, 2016 12:36:40 PM

144909

Page 2

Item ID: D212-580-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Dual Cargo Mirror Installation
 Start Date: 4/28/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/2/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC4- 100% Inspect kits for completeness	0.03							
170									
QC	Memo	0.03							
Quality Control									
180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D212--580-041 LOCATION: FG010								
190	QC21- Final Inspection - Work Order Release	0.10							
190									
QC	Memo	0.10							
Quality Control									

DAS
27
9-89
MAY 03 2016

DAS
27
9-89

MAY 03 2016

MAY 03 2016

ML5

dm

16/05/03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
						Completed By															
						Lead hand / Supervisor Approval Verification															
			QC / QA Coordinator Approval																		
Root Cause			FAULT CATEGORY																		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : ☐																					

Picklist Print

April 27, 2016 12:36:44 PM

Page 1

Work Order ID: 144909

144909

Parent Item: D212-580-041

D212-580-041

Parent Item Name: Dual Cargo Mirror Installation

Start Date: 4/28/2016

Required Date: 5/2/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H Removed D2013-3/-4 06-03-22 JLM
IPP REV:I AS PER ECN10-611 10-09-07 JLM VERIFIED
BY:DD IPP rev:J
10.11.22 AS PER ECN10-642 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3439-101 *D3439-101* Mirror Assembly 8"		Manufactured	No			100	Each	9.0000	2	2		DAS 6 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST383				9					
				140521				9					
D2161-212 *D2161-212* Mirror Bracket, 212		Manufactured	No			100	Each	1.0000	1	1		DAS 6 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST226				1					
				140805				1					
MS20426AD3-4 *MS20426AD3-4* RIVET		Purchased	No			100	Each	6,123.000	8	8		DAS 6 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				CCK004				4885					
				m134294				4885					
				GA				996					
				m131697				996					
				ST312				242					
				m131697				242					

Picklist Print

April 27, 2016 12:36:44 PM

Page 2

Work Order ID: 144909

144909

Parent Item: D212-580-041

D212-580-041

Parent Item Name: Dual Cargo Mirror Installation

Start Date: 4/28/2016

Required Date: 5/2/2016

Start Qty: 1.00

Required Qty: 1.00

D4164-041 Manufactured No

100 Each

21.0000

4 4

D4164-041

Nut Plate Adapter Assembly

**

DAS
6
9-89

EAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST088

21

118921

6

129429

15

MS27039-1-08

Purchased No

100 Each

441.0000

4 4

MS27039-1-08

Screw

**

DAS
6
9-89

DAS
28

APR 30 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

83

m128636

83

GA

73

125654

2

m128636

71

ST281

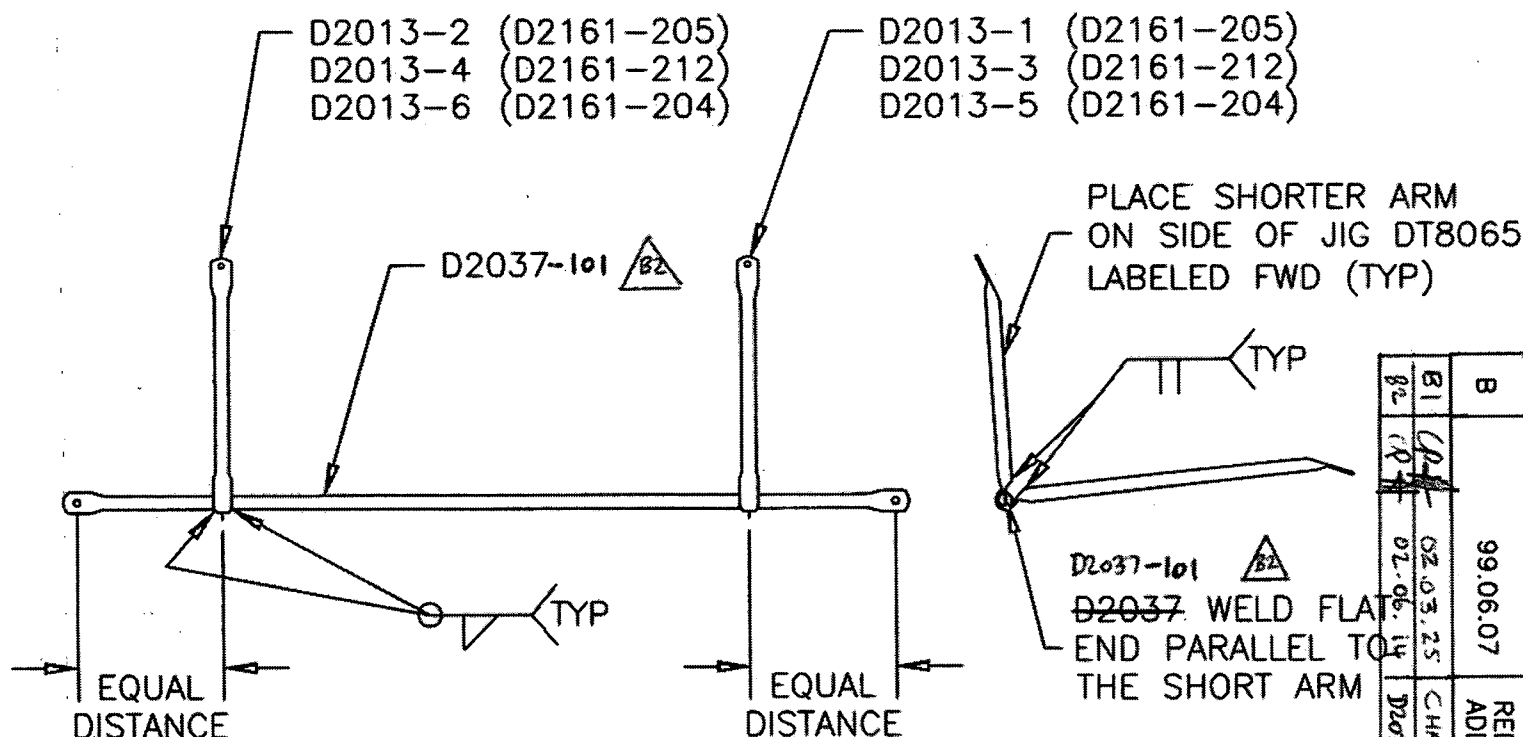
285

m134502

285



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
JB	RT	HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RT	DRAWING NO.	SHEET 1 OF 1
DATE 99.06.07		D2161	SCALE NTS
		TITLE	
		MIRROR BRACKET	
		NEW ISSUE	
		REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS	
		CHANGE FINISH	
		D2037-101 W/	
		RELEASED KE 99.06.10	



NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
~~POWDER COAT BLACK SANDTEX (4.3.5.7) PER~~
~~DART QSI 005 4.3~~

DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212



DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury, ON, K6A 1K7
CANADA

Tel: 1 613 632 5200
Fax: 1 613 632 5246

e-mail: heli@dartaero.com
<http://www.dartaero.com>

INSTALLATION INSTRUCTIONS

IIN-D212-580-1

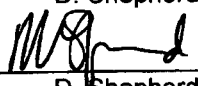
Dual Mirror Installation

**BELL 204/205/210/212/214/412 MODELS
AB412/AB412EP MODELS**

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: 	
D. SHEPHERD (DE # 02)	
DATE: 12.06.13	
CERT. NO.: SH92-16	
ISSUE NO.: #4	

Prepared By: 
Kevin Barton, C.E.T.

Checked By: 
D. Shepherd, P. Eng

Released By: 
D. Shepherd, P. Eng

• COPYRIGHT © 2010 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **B**
Date: 12.06.13

REVISION RECORD

Revision	Date	Description
A	10.07.20	New Issue
B	12.06.13	Incorporated DSI 9615

• COPYRIGHT © 2010 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **B**
Date: 12.06.13

Table of Contents

1.0	INTRODUCTION.....	4
1.1	Purpose	4
1.2	Background.....	4
1.3	Compatibility	4
1.4	Workmanship	4
1.5	Fastener Torque	4
1.6	Continuing Airworthiness	4
2.0	INSTALLATION PROCEDURE	5
2.1	Installation of D204-562-041 Dual Mirror (Bell 204)	5
2.2	Installation of D205-563-041 Dual Mirror (Bell 205)	5
2.3	Installation of D212-580-041 Dual Mirror (Bell 210/212/214/412)	5
3.0	WEIGHT AND BALANCE.....	9
4.0	PARTS LIST	10

• COPYRIGHT © 2010 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **B**

Date: 12.06.13

1.0 INTRODUCTION

1.1 Purpose

The purpose of this report is to outline the procedure for the installation of the D204-562-041, D205-563-041, and D212-580-041 Dual Mirror Installations on the Bell 204/205/210/212/214/412 model helicopters.

1.2 Background

The Dart Dual Mirror Installation mounts to the nose of the Bell 204/205/210/212/214/412 and AB412/AB412EP model aircraft to provide better viewing of the cargo hook for pickup and release. There are three installations:

DART INSTALLATION	AIRCRAFT
D204-562-041	204B
D205-563-041	205A/A1
D212-580-041	205B/210/212/214B/214B1/ 412/412EP/412CF/AB412/AB412EP

Table 1-1: Installation Compatibility

1.3 Compatibility

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

1.4 Workmanship

Unless otherwise stated, all workmanship should be the standards set by the Aircraft Maintenance Manual. The customer has the option of replacing screws that are too short/long with the correct screw length, ensuring that there are a minimum of 1.5 threads exposed after the nut. **Screws that do not have the minimum of 1.5 threads exposed after the nut must be replaced with longer screws by the customer.**

1.5 Fastener Torque

Fastener torque is as follows unless otherwise specified.

Size	Torque	
8-32	12-15 in-lbs	1.4-1.7 N-m
3/16"	20-25 in-lbs	2.3-2.8 N-m
1/4"	50-70 in-lbs	5.6-7.9 N-m
5/16"	100-140 in-lbs	11.3-15.8 N-m
3/8"	160-190 in-lbs	18.1-21.5 N-m

Table 1-2: Fastener Torque

1.6 Continuing Airworthiness

These installations should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D212-580.

• COPYRIGHT © 2010 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **B**
Date: 12.06.13

2.0 INSTALLATION PROCEDURE**2.1 Installation of D204-562-041 Dual Mirror (Bell 204)**

(Refer to Figure 2-1)

- 2.1.1 Locate the 3rd and 11th anchor nut on both sides of the forward nose panel as shown in Figure 2-1. Remove existing screws.
- 2.1.2 Install the D2161-204 Mirror Bracket using MS27039-1-08 screws as shown in Figure 2-1.
- 2.1.3 Torque the screws per Table 1-2.
- 2.1.4 Install the D3439-101 Mirrors onto the D2161-204 Mirror Bracket using D3015-3 Locknuts and AN960JD516 washers as shown in Figure 2-1 (2 places). Torque the nuts per Table 1-2.

2.2 Installation of D205-563-041 Dual Mirror (Bell 205)

(Refer to Figure 2-2)

- 2.2.1 Locate the 2nd and 6th anchor nut on both sides of the forward nose panel as shown in Figure 2-2. Remove existing screws.
- 2.2.2 Install the D2161-205 Mirror Bracket using MS27039-1-08 screws as shown in Figure 2-2.
- 2.2.3 Torque the screws per Table 1-2.
- 2.2.4 Install the D3439-101 Mirrors onto the D2161-205 Mirror Bracket using D3015-3 Locknuts and AN960JD516 washers as shown in Figure 2-2 (2 places). Torque the nuts per Table 1-2.

2.3 Installation of D212-580-041 Dual Mirror (Bell 210/212/214/412)

(Refer to Figure 2-3, for better viewing, install per Figure 2-4)

- 2.3.1 If installing per Figure 2-3, locate the 4th stud positions (STA 10.0) on both sides of the forward nose panel as shown in Figure 2-3. Remove the SV4P-2 stud (or equivalent) and V4-106 retainer (or equivalent) as shown in Figure 2-3 (2 places). Install the D4164-041 Nut Plate Assembly using MS20426AD3-4 Rivets as shown in Figure 2-3 (2 places).
- 2.3.2 If installing per Figure 2-4, locate the 2nd and 6th stud positions on both sides of the bottom nose panel as shown in Figure 2-4. Remove the SV4P-2 stud (or equivalent) and V4-106 retainer (or equivalent) as shown in Figure 2-4 (4 places). Install the D4164-041 Nut Plate Assembly using MS20426AD3-4 rivets (2) as shown in Figure 2-4 (4 places).
- 2.3.3 Install the D2161-212 Mirror Bracket:
 - a) Align the D2161-212 Mirror Bracket as shown in Figure 2-3 / Figure 2-4.
 - b) Install the D2161-212 Mirror Bracket using MS27039-1-08 screws as shown in Figure 2-3 / Figure 2-4.
 - c) Torque the screws per Table 1-2.
- 2.3.4 Install the D3439-101 Mirrors onto the D2161-212 Mirror Bracket using D3015-3 Locknuts and AN960JD516 washers as shown in Figure 2-3/Figure 2-4 (2 places). Torque the nuts per Table 1-2.

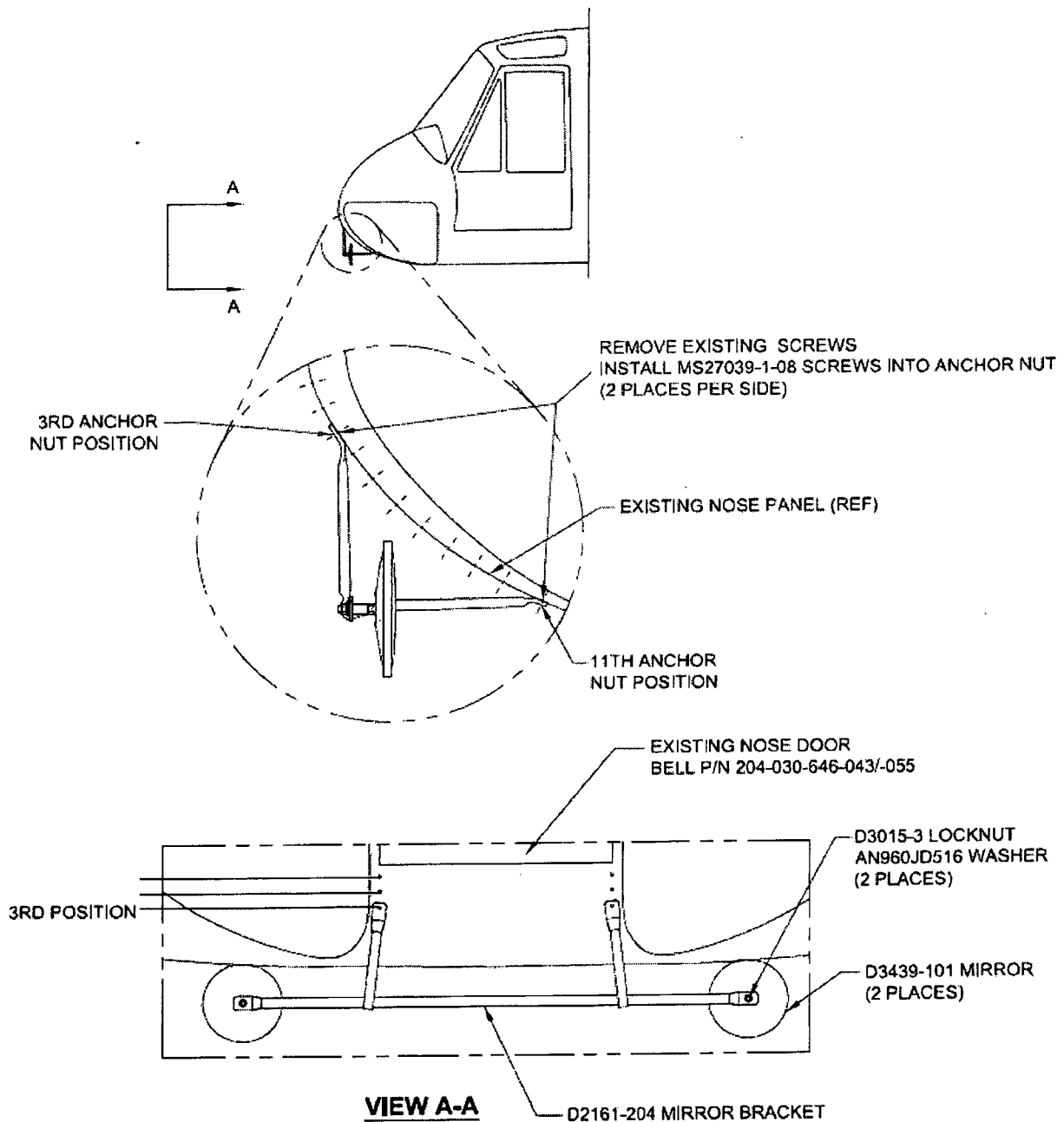


Figure 2-1: D204-562-041 DUAL MIRROR INSTALLATION

• COPYRIGHT © 2010 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **B**
Date: 12.06.13

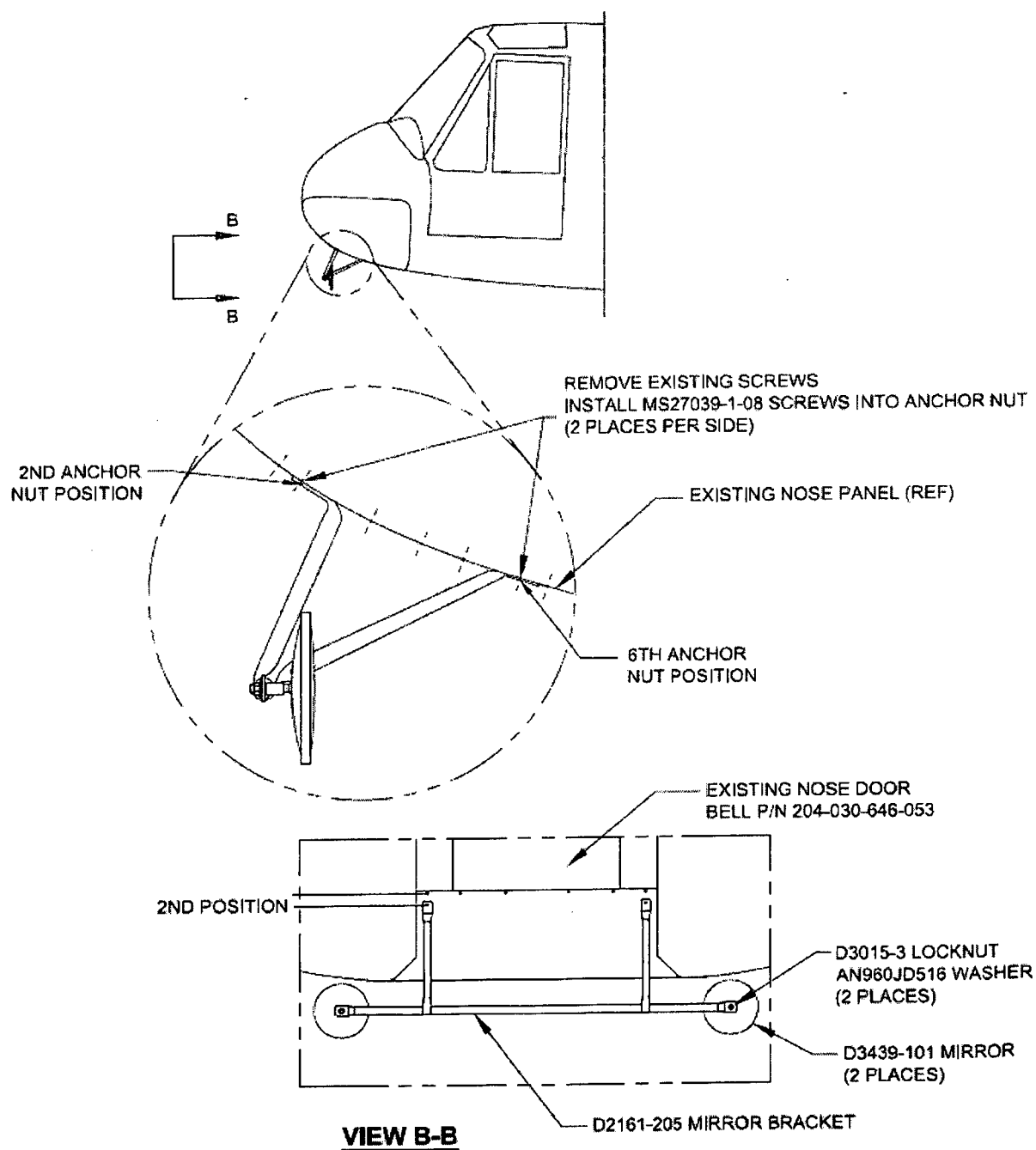
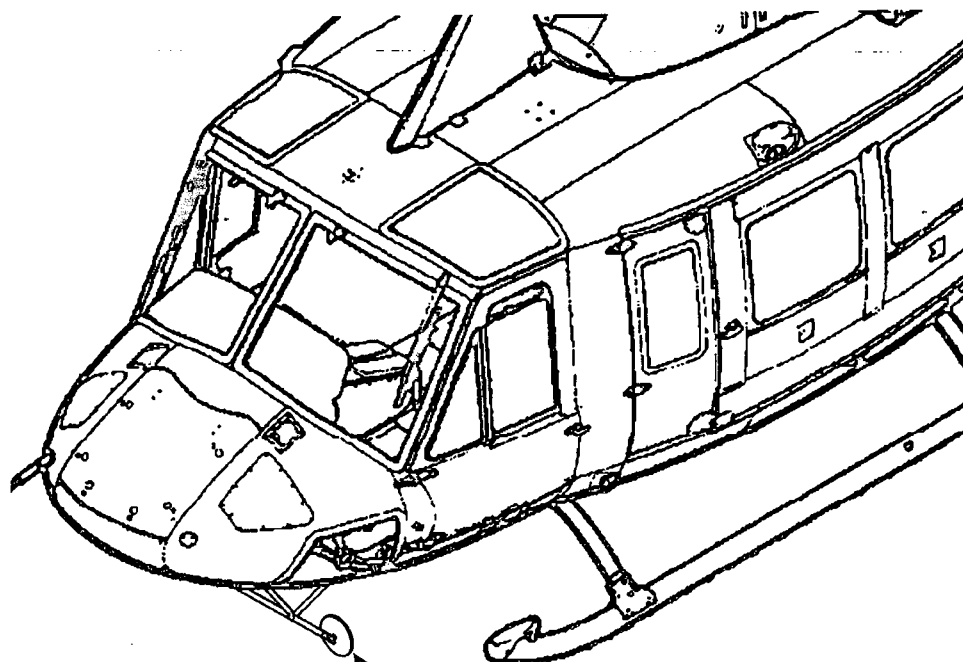


Figure 2-2: D205-563-041 DUAL MIRROR INSTALLATION

• COPYRIGHT © 2010 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **B**
Date: 12.06.13



D212-580-041 DUAL MIRROR INSTALLATION
(DETAIL C)

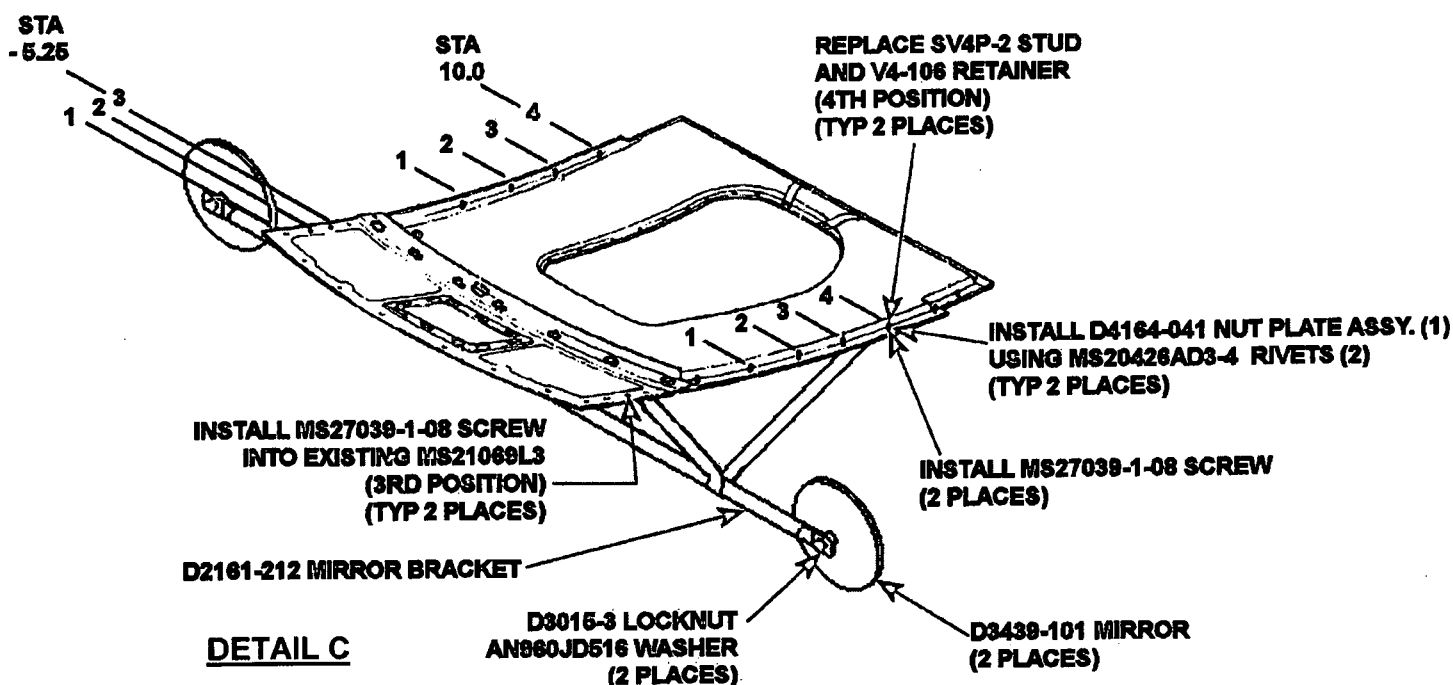


Figure 2-3: D212-580-041 DUAL MIRROR INSTALLATION (OPTION 1)

• COPYRIGHT © 2010 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **B**
Date: 12.06.13

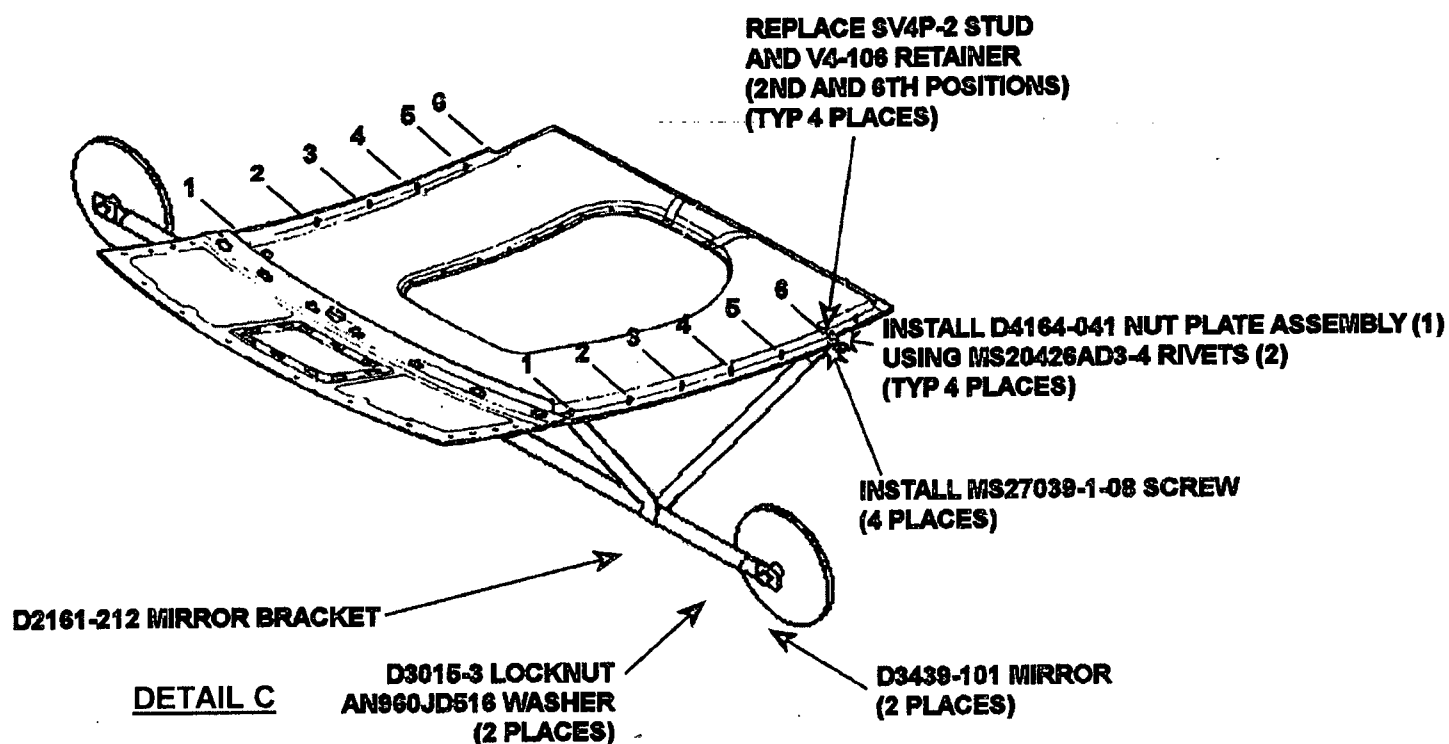


Figure 2-4: D212-580-041 DUAL MIRROR INSTALLATION (OPTION 2)

3.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D204-562-041	5.0 lb	0 in	0 lb-in	3.80 in	19.0 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	0.10 m	0.23 m-kg
D205-563-041	5.0 lb	0 in	0 lb-in	3.80 in	19.0 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	0.10 m	0.23 m-kg
D212-580-041	5.0 lb	0 in	0 lb-in	-5.25 in	-26.3 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	-0.13 m	-0.30 m-kg

• COPYRIGHT © 2010 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **B**

Date: 12.06.13

4.0 PARTS LIST

Qty 562 -041	Qty 563 -041	Qty 580 -041	Part Number	Description
X			D204-562-041	DUAL MIRROR INSTALLATION
	X		D205-563-041	DUAL MIRROR INSTALLATION
		X	D212-580-041	DUAL MIRROR INSTALLATION
2	2	2	D3439-101	MIRROR (WAS D2011-103)
1			D2161-204	MIRROR BRACKET
	1		D2161-205	MIRROR BRACKET
		1	D2161-212	MIRROR BRACKET
*2	*2	*2	D3015-3	LOCKNUT
*2	*2	*2	AN960JD516	WASHER
		8	MS20426AD3-4	RIVET, COUNTERSUNK
		4	D4164-041	NUT PLATE ASSEMBLY
4	4	4	MS27039-1-08	SCREW

* PARTS ARE INCLUDED WITH D3439-101 MIRROR

• COPYRIGHT © 2010 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **B**
Date: 12.06.13

Work Order ID 144909

April 27, 2016 12:36:40 PM

144909

Page 1

Item ID: D212-580-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual Cargo Mirror Installation

Start Date: 4/28/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/2/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: em SW Date: 16/04/27

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2161	B2								
IIN-D212-580-1	B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D212-580-041 CHG004								
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									

MLJ MAY 02 2016

REFERENCE ONLY

4.0 PARTS LIST

Qty 562 -041	Qty 563 -041	Qty 580 -041	Part Number	Description
X			D204-562-041	DUAL MIRROR INSTALLATION
	X		D205-563-041	DUAL MIRROR INSTALLATION
		X	D212-580-041	DUAL MIRROR INSTALLATION
2	2	2	D3439-101	MIRROR (WAS D2011-103)
1			D2161-204	MIRROR BRACKET
	1		D2161-205	MIRROR BRACKET
		1	D2161-212	MIRROR BRACKET
*2	*2	*2	D3015-3	LOCKNUT
*2	*2	*2	AN960JD516	WASHER
		8	MS20426AD3-4	RIVET, COUNTERSUNK
		4	D4164-041	NUT PLATE ASSEMBLY
4	4	4	MS27039-1-08	SCREW

* PARTS ARE INCLUDED WITH D3439-101 MIRROR

• COPYRIGHT © 2010 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B

Date: 12.06.13